

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2017-210 Date Opened: 5 December 2017 Title: FabricationAircraft OEM: Multiple Aircraft Model: Multiple Product Type: Spacers Product Model: N/A Quantity: 200**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

CB/JC
N/A
CB/JC
CB/JC
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
49216	1	Basket comp. spacer	CB/JC

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

228
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
JC
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: M. REKVE / J. CLARKESign: [Signature]SCA: AD02Date: 18 May 2018

ICC / Dual Inspection performed by:

Print: N/A JCSign: [Signature]SCA: AD02Date: 18 May 2018

Work Order closed by:

Print: J. CLARKESign: [Signature]SCA: AD02Date: 18 May 2018

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: SPACER No. of pieces: 249

Manufacturer: AERO DESIGN LTD.

Part No.: 49216-01 Serial/Batch No.: PO 17050

TTSN: NP TSO: N/A Rem.: N/A

Work Order No.: 2017-210

Remaining Tasks to be Performed: MACHINING, - 1 PULLED OUT OF

COLLET &

Signature: JH CCL

Date: 05 DEC 2017 Lic. No. / SCA AD02

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

-30 Pulled for Completion 06 Dec 2017 JC.

- Broken drill bit JC

-S2 COMPLETED JAN. 25, 2018 JC.

-146 Completed 18 May 2018 JC.

BUSHING/TUBE/GUIDE/THREADED LUG

General

These general instructions apply to bushings, tubes and similar round components used for Aero Design cargo baskets, mounting beams, and other products. Refer to the drawing, at the current revision, for dimensions and details. Selected drawings with applicable parts, drawings not listed may also apply:

69830 – Bell 206L/407 Mounting Beam
76630 – Bell 206L/407 High Mounting Beam
78633 – Airbus AS350 Aft Beam
78634 – Airbus AS350 Forward Beam
49215 – Lid Prop Bushing
49216 – Lid Prop Bushing

76423 – Airbus AS350 Attachment Hoop
94023 – Airbus AS350 XL Attachment Hoop
82715 – Airbus AS350 Short Step Assembly
82733 – Airbus AS350 Short Step Bracket
36274 – Handle Lever Bushing
36275 – Handle Support and Bushing

Work Order: 2017-210

Batch Quantity: 200

Complete
(initial or SCA #)

Date Open: 5 Dec. 2017

Part Number: 49216-1

228 complete JK.

NR JK.

1. Cut stock material:

- Enter material PO:
- Cut stock to length, + 0.03-0.06".
- Tag in-progress parts and place on in-progress shelf in machine shop.

PO: 17050

2. Turn stock material:

CNC 49201 + 49202 JK.

NR JK.

CAUTION: Using a lathe requires training and is not to be undertaken without adequate instruction and knowledge of the processes and settings involved. Do not attempt to fabricate parts on the lathe if you are unsure of what is required to safely produce the part.

Note: Not all steps may apply to all parts. Strike out any step(s) that does not apply.

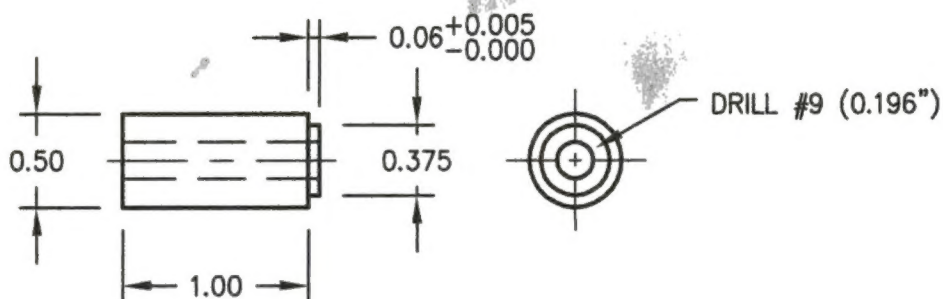
Note: Feeds and speeds are recommended starting point for aluminum, steel, and stainless steel up to 1" in diameter using the appropriate inserts. Adjust for optimal performance and finish.

- Face one end flat @ 1000 RPM, cross feed @ 0.01"/rev roughing, 0.004"/rev finishing.
- Turn outside @ 1000 RPM, feed @ 0.01"/rev roughing, 0.004"/rev finishing.
- Centre drill and drill at 300 RPM (up to 5/16", reduce for larger sizes).
- Setup stop and face other end to length @ 1000 RPM.
- De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Tag complete parts.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	REFORMAT TO LETTER; TITLE BLOCK UPDATED; ALTERNATE MATERIAL ADDED	BJC	MAR 13/14


NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.



01 SPACER

		01	(ALTERNATE MATERIAL)	304 STAINLESS STEEL	ASTM A479	ø1/2" OD BAR
	49216-01	01	SPACER	MILD STEEL	AISI 1010/1020	ø1/2" OD BAR
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

NOTICE --- THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.	APPROVALS	DATE		AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca		
	DRAWN: STEVEN FAHEY	MAY 10/02				
	CHECKED: E. BURGAIN	MAY 10/02				
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		HELICOPTER CARGO BASKET BASKET COMPONENTS – SPACER			
	DECIMALS	ANGLES				
X.XXX ±0.010	±1/2°	SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.	
X.XX ±0.03		SHEET 1 OF 1	A4	49216	1	
X.X ±0.1						

QTY 200

1.063 finished

1.090 Mex



100



